

DRAW GREEN

Work Order ID 65513

January 19, 2011 11:30:35 AM



Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2571	Rev E								

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 65513 Double check by: B.A. U1-Machine Step No 1  
per Folio FA051 and inspect per attached Dimension Sheets U2-Machine Step  
No 2 per Folio FA051 and inspect per attached Dimension Sheets U3-Machine  
Step No 3 per Folio FA051 and inspect

SL 11/01/27 (10)

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

SL 11/01/27

10 0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

SL 11/01/27

10 0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65513

January 19, 2011 11:30:35 AM



Page 2

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish	Memo	0.00							
Hand Finishing									
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating									

BA 11/01/27

10 0

10 BR 11-01-28

POWDER COAT DRAB GREEN  
PER QSI 005[]  
START TIME: 10:45  
FINISH TIME: 11:15  
LOVEN TEMPERATURE: 320°F

10X m-f 11/03/01

M 104476

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 65513

January 19, 2011 11:30:36 AM



Page 3

Item ID: D2571

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd Out 205

Start Date: 1/20/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/11/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

10 6 11 4/03/01

170

Identify as per dwg & Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/3/1 5f 102

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/03/02 11/03/02

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

January 19, 2011 11:30:34 AM

Page 1

Work Order ID: 65513



Parent Item: D2571



Parent Item Name: Saddle, Fwd Out 205

Start Date: 1/20/11

Required Date: 2/11/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP: I02.10.02 Re-format; Change to Dwg Rev. D & incorporated  
D2572 KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D6101-007

Manufactured

No

100

Each

18.0000

1

10



Saddle Billet

2 11/01/06

Location

Loc Qty

Loc Code

MAT42

18

46412

2

✓ 62713

16

10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 65513
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.442	.442	.442	.442	Vern	11-3
B	1.745	1.755		1.750	1.750	1.750	1.750		"
C	3.495	3.505		3.500	3.500	3.500	3.500		"
D	1.745	1.755		1.750	1.750	1.750	1.750		"
E	7.990	8.010		8.003	8.001	8.001	8.001	Vern	CNC-D2
F	0.490	0.510		.502	.502	.502	.503		"
G	0.257	0.262		.258	.258	.258	.258		"
H	0.375	0.380		.376	.376	.376	.376		"
I	0.490	0.510		.501	.502	.502	.501		"
J	1.174	1.184		1.179	1.179	1.179	1.179		"
K	0.558	0.578		.568	.568	.568	.569		"
L	1.174	1.184		1.179	1.179	1.179	1.179		"
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125	mic	118-120
Q	0.115	0.135		.135	.135	.135	.135		"
R	0.240	0.260		.251	.250	.250	.251		"
S	0.115	0.135		.129	.130	.130	.127	mic	118-120
T	0.178	0.198		.188	.188	.188	.188	R-G	"
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.239	.241	.238		
W	0.115	0.135		.124	.122	.125	.124	mic	118-120
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.363	.363	.365	.364		"
AA	0.470	0.530		.500	.500	.500	.500	R-G	
AB	0.615	0.635		.626	.627	.625	.626		"
AC	0.053	0.073		.063	.063	.063	.063	R-G	
AD	0.240	0.260		.247	.246	.249	.248		"
AE	1.375	1.395		1.391	1.389	1.388	1.390	dial	
AF	0.115	0.135		.135	.135	.135	.135		"
AG	0.240	0.280		.260	.260	.260	.260		"
AH	0.240	0.260		.247	.248	.251	.251		"
AI	2.000	2.020		2.005	2.003	2.002	2.003	dial	
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: SL
Date: 11/01/24

Audited by: M.A
Date: 11/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 65513
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.442	.442	.442	.442		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.010	8.008	8.001		
F	0.490	0.510		.501	.505	.501	.501		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.501	.501	.502	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.568	.570	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.126	.126	.126		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.129	.129	.129	.129		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.238	.238	.239	.240		
W	0.115	0.135		.125	.125	.125	.124		
X	0.308	0.313		.311	.311	.311	.311		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.366	.363	.362	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.626	.626	.628	.626		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.248	.247	.249	.248		
AE	1.375	1.395		1.390	1.390	1.389	1.389		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.247	.247	.248	.248		
AI	2.000	2.020		2.004	2.005	2.003	2.004		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	JL
Date:	11/01/27

Audited by:	J.A
Date:	11/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 165513
<b>Description:</b> Saddle, Fwd Outboard	<b>Part Number:</b> D2571
<b>Inspection Dwg:</b> D2571 Rev. E	<b>Page 1 of 1</b>

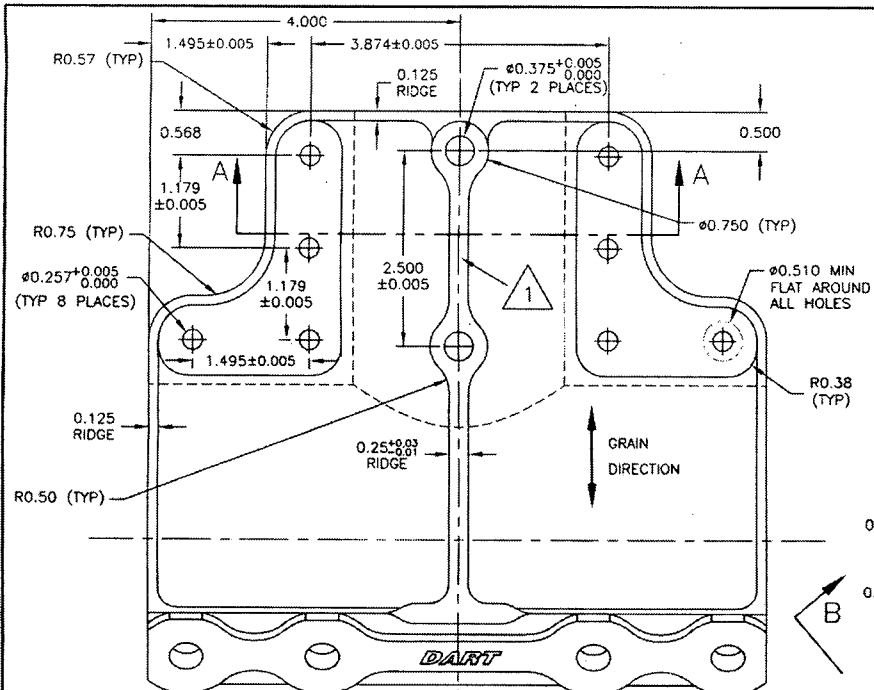
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.438	0.443		.442	.442				
B	1.745	1.755		1.750	1.750				
C	3.495	3.505		3.500	3.500				
D	1.745	1.755		1.750	1.750				
E	7.990	8.010		8.001	8.002				
F	0.490	0.510		.503	.502				
G	0.257	0.262		.258	.258				
H	0.375	0.380		.376	.376				
I	0.490	0.510		.501	.495				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.569	.567				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.495	1.495				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.125	.126				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.250				
S	0.115	0.135		.125	.129				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.960	2.960				
V	0.230	0.250		.240	.239				
W	0.115	0.135		.124	.124				
X	0.308	0.313		.311	.311				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.363	.364				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.626	.625				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.248	.247				
AE	1.375	1.395		1.389	1.390				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.248	.248				
AI	2.000	2.020		2.003	2.005				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

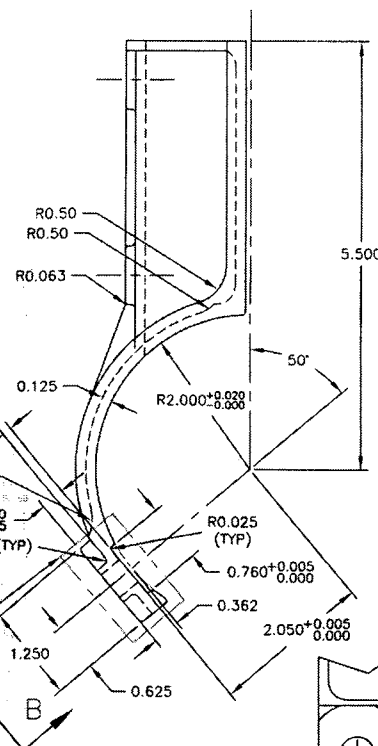
Measured by:	JL
Date:	11/01/27

Audited by:	M.A
Date:	11/01/27

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



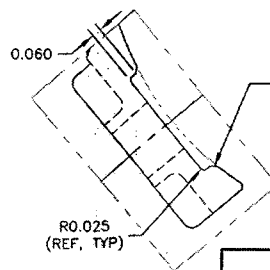
DETAIL C



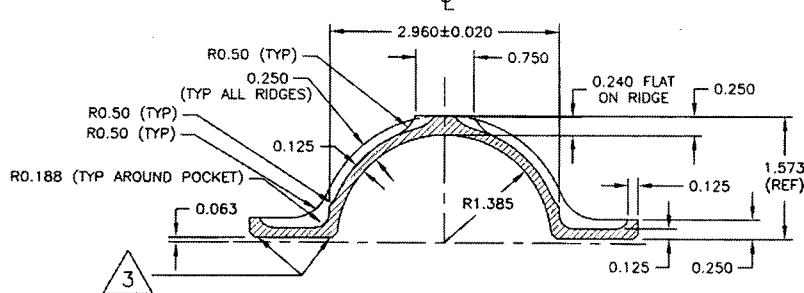
DETAIL C

0.06

(TYP)



DETAIL C  
SCALE 4:3









SECTION A-A

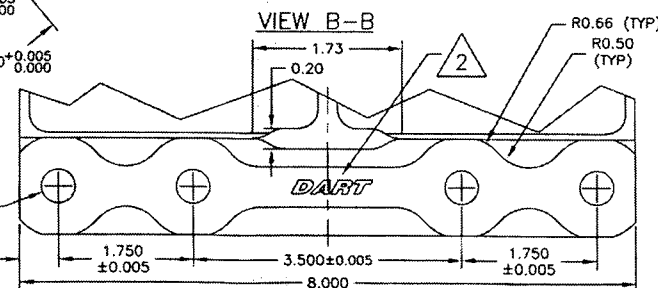
2065513

## NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART  
QSI 005 4.3  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- |   |   |
|---|---|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010  |
|  | ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125  |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)   |
|  | CHAMFER 0.063" x 45° ALL AROUND   |
|  | CHAMFER 0.033" x 45° (SEE DETAIL C)  |

$\triangle E$



E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCOMP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRASS DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

DESIGN DS	DRAWN BY PH	<b>DART</b>	DART AEROSPACE LTD. HARRISBURY, ONTARIO, CANADA
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2571	REV. SHEET 1 OF 2
DATE 05.07.13	TITLE OUTER FWD SADDLE		SCALE 2:

**COPYRIGHT © 2005 BY DART AEROSPACE LTD.**

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL  
AND IS SUPPLIED ON THE EXPRESS CONDITION  
THAT IT IS NOT TO BE USED FOR ANY PURPOSE  
OR COPIED OR COMMUNICATED TO ANY OTHER  
PERSON WITHOUT WRITTEN PERMISSION FROM  
DART AEROSPACE LTD

	DRAWING NO
	D2571

TITLE	OUTER FWD SADDLE
-------	------------------

REV. 6  
SHEET 1 OF  
SCALE  
2:3